

Date: Tuesday, 4/25/2006 8:34:31 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 26793					
Estimate Number	: 10845					
P.O. Number	: N/A		Part Number	: D32833		
This Issue	: 4/25/2006	S.O. No. : N/A	Drawing Number	: D3283 REV D		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: 4/25/2006	Type : MACHINED PARTS	Drawing Revision	: D		
Previous Run	: 25879		Material	: N/A		
Written By	<i>See Comment Below</i>		Due Date	: 5/7/2006		
Checked & Approved By	<i>4/25/06.04.25</i>		Qty:	40	Um:	Each
Comment	: Est A 04.09.28 New issue KJ/JLM					

Additional Product

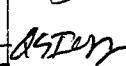
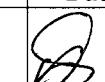
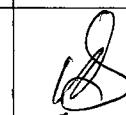
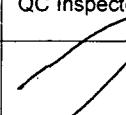
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet Comment: Qty.: 0.3465 sf(s)/Unit Total : 13.8600 sf(s) 6061-T6 .080 Sheet Material: 6061-T6 (QQ-A-250/11) 0.080" thick (M6061T6S.080) Identify for D3283-3 Batch: <u>M6973</u>
2.0	SHEAR	SHEAR Comment: SHEAR Cut blanks: 15.550" X 2.450
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA424 and Dwg D3283 Stack of 10 Identify as D3283-3
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/17	3	Some holes had deep water jet marks on the side making the hole larger on one side than the other. 3 parts scrapped.	 	Scraped off.	 06/05/17	 06/05/17	 06/05/17	 06/05/17

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

H.M 06/05/23 37

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F. 06/05/24
H.M 06/05/24

(37)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY19

6/5/24 37

11.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

OK 06/05/25 37

Job Completion



OK 06/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

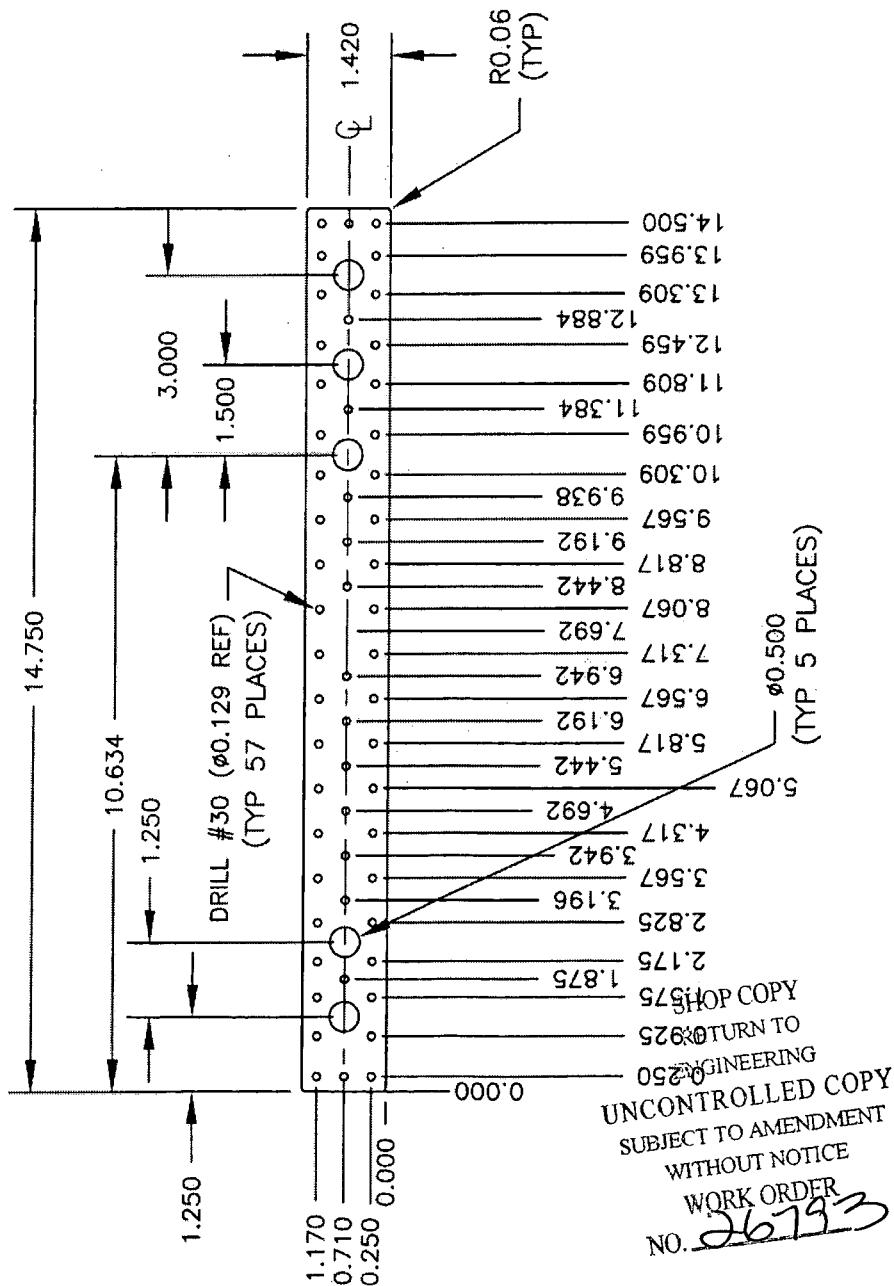
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3283	REV. D SHEET 1 OF 2
DATE 05.08.09		TITLE DOUBLER	SCALE 1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	

RELEASED
05-07-06 #

05.09.06 ff



D3283-1 DOUBLER

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063).
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

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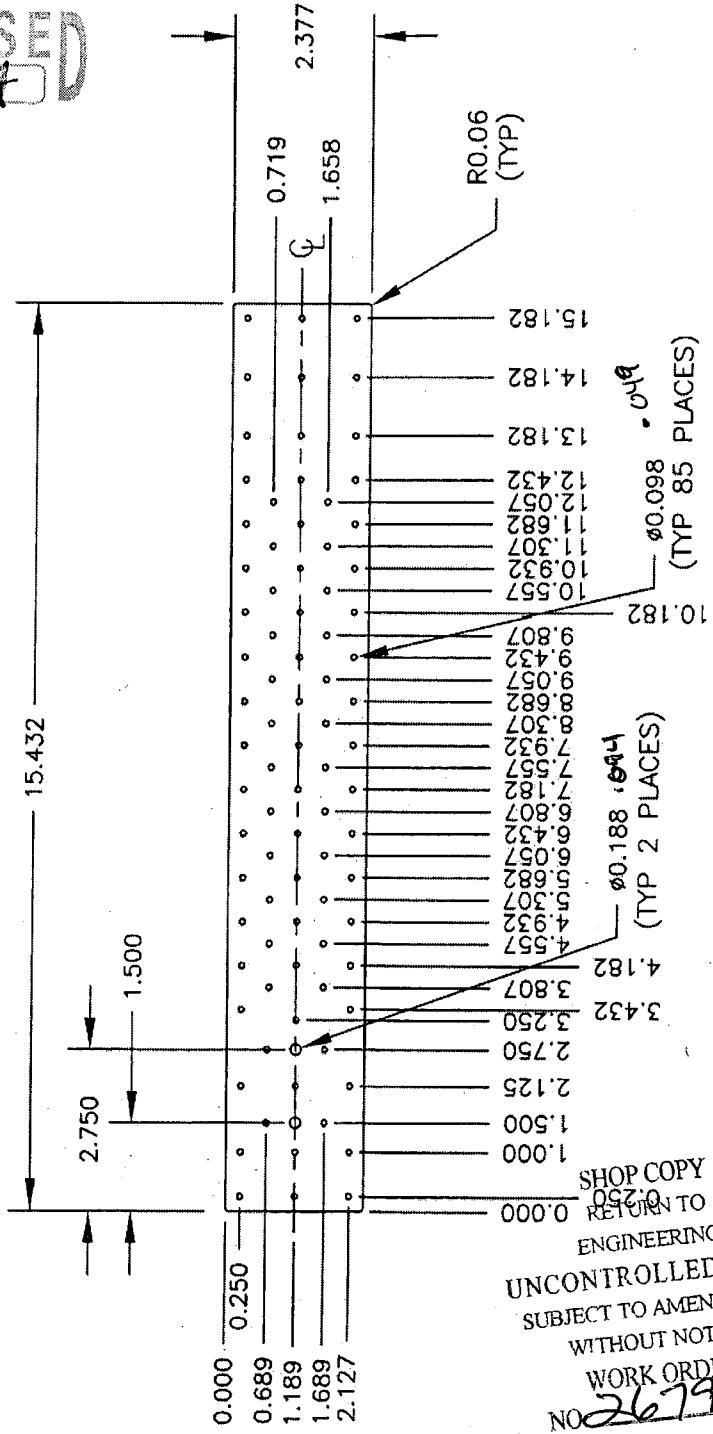
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3283	REV. D SHEET 2 OF 2	
DATE 05.08.09		TITLE DOUBLER	SCALE 1:3	

RELEASED
05-09-06 *[Signature]*

05.09.06



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF. DART SPEC. M6061T6S.080)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	26793
Description:	Part Number:	D3283-3
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>JM</u>	Audited by:	<u>C</u>	Prototype Approval:	
Date:	06.05.11	Date:	06.05.11	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	